

Work Order ID 72183

Tuesday, July 19, 2011 2:29:44 PM



Page 1

Item ID:	D3908-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Crosstube Lug Assembly, Aft <i>7</i>				Stop	
Start Date:	7/19/2011	Start Qty:	<i>1.00</i>			
Required Date:	7/21/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	<i>MF</i>	Date:	<i>11-07-19</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3908	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg TRIM RIVETS 1.185" LONG								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

GP 11/07/20 *(7)*

GP 11/07/20 *(7)*

S 11/07/20

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72183

Page 2

Tuesday, July 19, 2011 2:29:44 PM

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *change 471* 0.00

Packaging

Memo

0.00

Packaging

*Place OK**11/7/2011* *7-0*

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*11/7/2011**ME**11-07-20*

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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 2:29:36 PM

Page 1

Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft



Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD
10.05.27 DD verf:EC
10.05.28 DD verf:EC
IPP REVB:
IPP Rev:C as per PC1
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 Lanyard Assembly		Manufactured	No			100	Each	40.0000	1	1			
<div> <div>Location</div> <div>ST020</div> <div>70920</div> </div> <div> <div>Loc Qty</div> <div>40</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3908-1 Lug Plate, Aft Crosstube		Manufactured	No			100	Each	17.0000	2	2			
<div> <div>Location</div> <div>ST090</div> <div>66167</div> <div>68259</div> </div> <div> <div>Loc Qty</div> <div>17</div> <div>3</div> <div>14</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3908-3 Stud Receiver, Lower		Manufactured	No			100	Each	13.0000	1	1			
<div> <div>Location</div> <div>ST090</div> <div>66172</div> <div>68260</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>5</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

EP 11/07/20

8
2
EP 11/07/20

2
14
EP 11/07/20

1
7

W/O:		WORK ORDER CHANGES					
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Tuesday, July 19, 2011 2:29:37 PM

Page 2

Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3908-5

 Eyebolt Stud

Manufactured No

100 Each

15.0000

1

1



EP 5/11/07/20

Location

Loc Qty

Loc Code

GA

1

57428

1

ST090

14

59670

2

65625

8

66185

4

84

D3910-1

 Crosstube Lug

Manufactured No

100 Each

32.0000

1

1



EP 5/11/07/20

Location

Loc Qty

Loc Code

ENG

30

70160

30

st507

2

68263

2

8

D4091-1

 Mounting Lug

Manufactured No

100 Each

22.0000

1

1



EP 5/11/07/20

Location

Loc Qty

Loc Code

ST460

22

69605

22

8

AN3C12A

 Bolts

Purchased No

100 Each

24.0000

2

2



EP 5/11/07/20

Location

Loc Qty

Loc Code

ST351

24

117514

4

118112

20

15

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No
BOLT



100 Each 23.0000



1

EP 11/07/20

Location

Loc Qty

Loc Code

ST357

23

117793

23

MS17984-C413 Purchased No
PIN, QUICK RELEASE



100 Each 16.0000



1

EP 11/07/20

Location

Loc Qty

Loc Code

ST315

16

114340

1

117557

15

MS20615-4120 Purchased No
RIVET



100 Each 100.0000



6

EP 11/07/20

Location

Loc Qty

Loc Code

GA

100

117071

100

MS21043-3 Purchased No
Nut



100 Each 776.0000



2

EP 11/07/20

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

704

112314

33

118077

671

16

M117411 (GPK)

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Page 4

Work Order ID: 72183

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 7/19/2011

Required Date: 7/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

100

Each

627.0000

1



Nut



ES 11/07/20

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

587

117601

87

117793

500

NAS1149C0332R

Purchased

No

100

Each

8,651.000

4



Washer



ES 11/07/20

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

8644

116304

55

117460

62

117887

247

118078

2

118179

86

118306

3192

118354

5000

NAS1149C0432R

Purchased

No

100

Each

4,920.000

2



Washer



ES 11/07/20

Location

Loc Qty

Loc Code

ST297

4920

116900

302

117291

4618

16

Tuesday, July 19, 2011 2:29:37 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

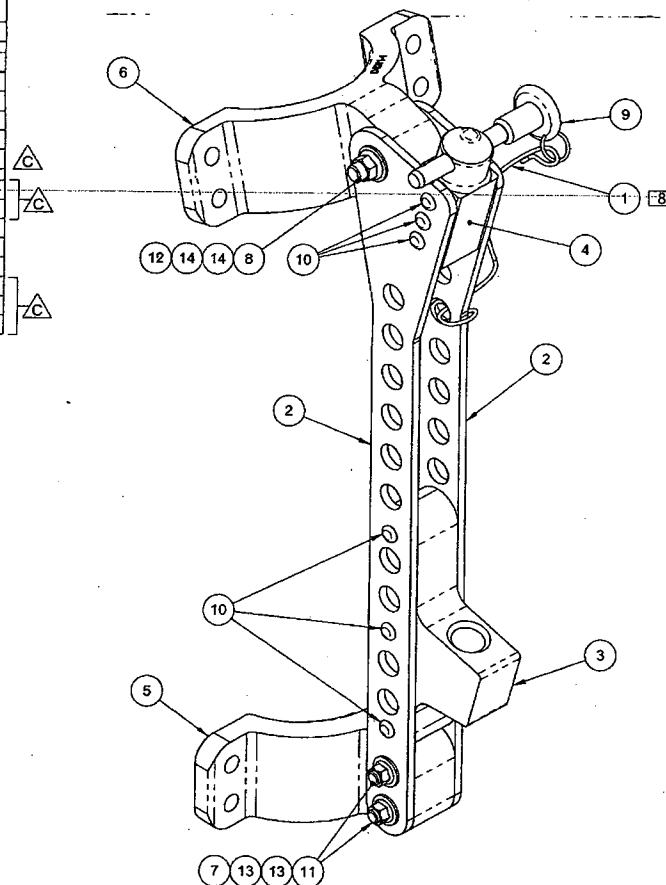
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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

RELEASED
2010-05-28
W

C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413, SHEET 5, ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.05.27		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

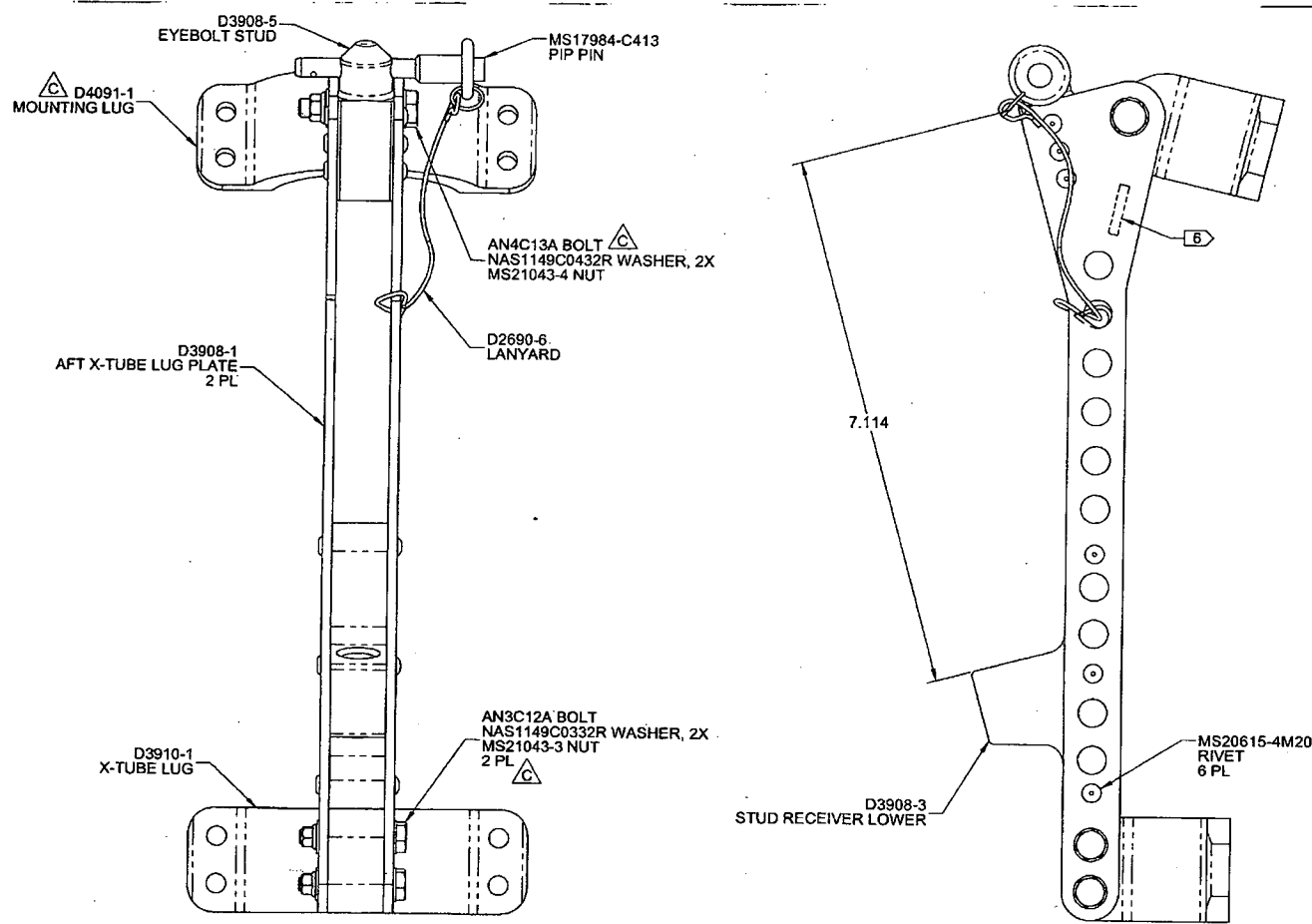
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NOTE: Date & initial all entries






8 7 6 5 4 3 2 1



72183

RELEASED
2010-05-28
JMP

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		
		DRAWING NO. D3908	REV. C
		TITLE X-TUBE LUG ASSY (AFT)	SHEET 2 OF 5
			SCALE NTS
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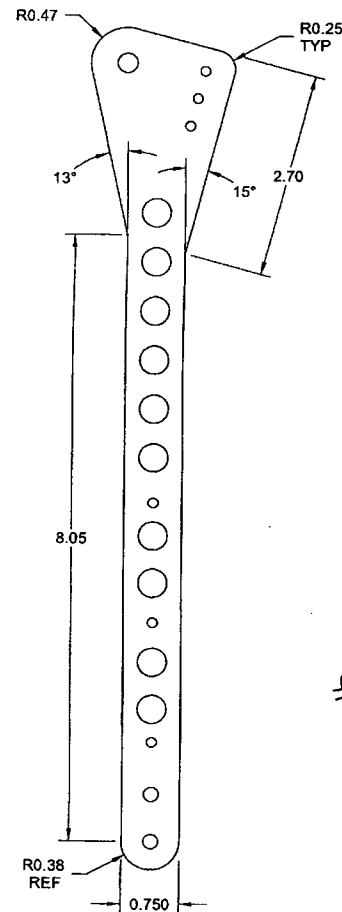
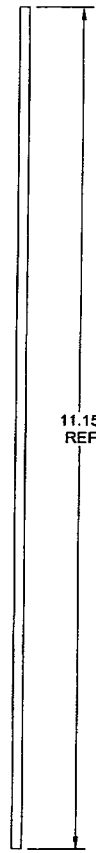
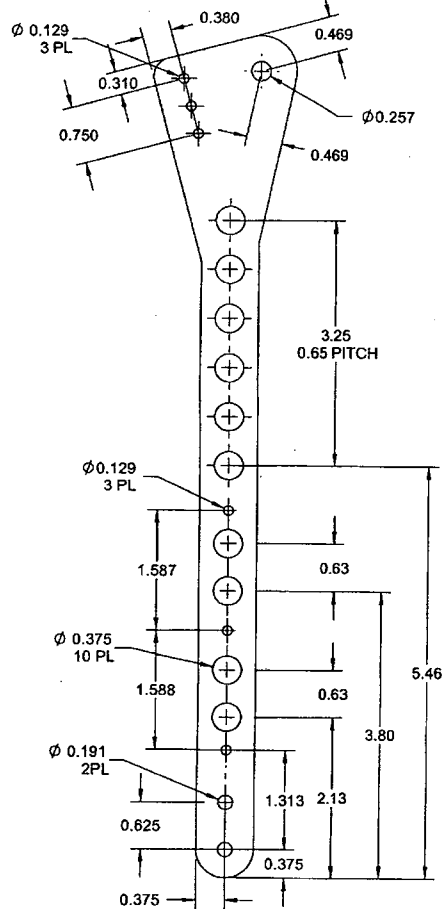
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#72183

RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3908	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		X-TUBE LUG ASSY (AFT)	SCALE
DE APPR.			NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SURPLUS ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

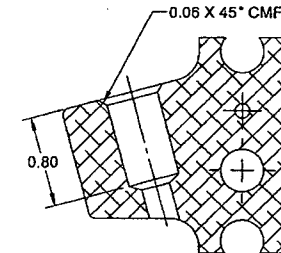
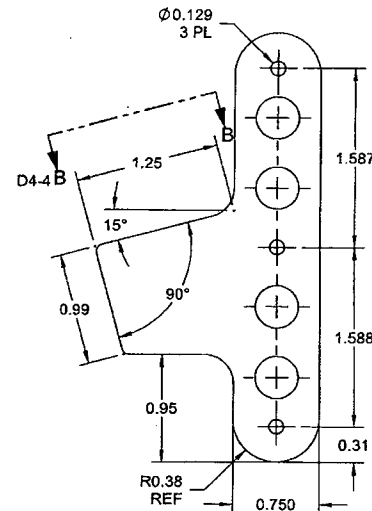
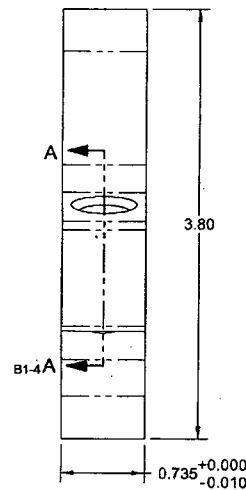
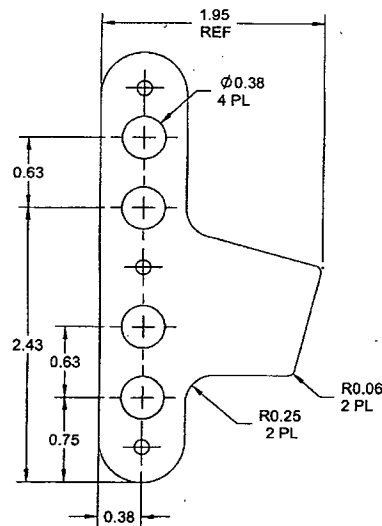
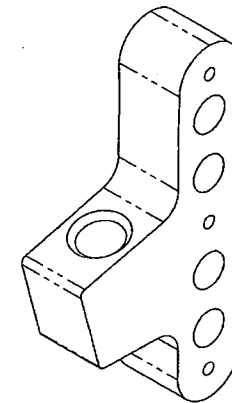
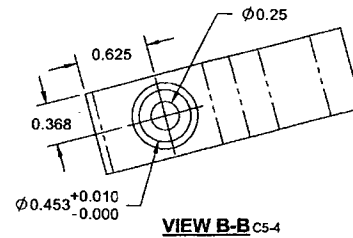
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NOTE: Date & initial all entries



D3908-3 STUD RECEIVER LOWER

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

#72183

RELEASED
2010-05-28

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3908	REV. C
CHECKED			SHEET 4 OF 5
MFG. APPR.		TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
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DE APPR.		DATE 10.05.27	

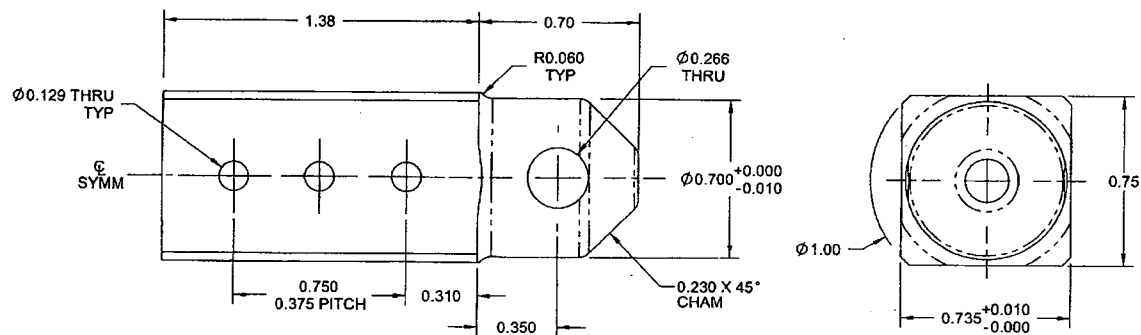
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NOTE: Date & initial all entries



D3908-5 EYEBOLT STUD

RELEASED
2010-05-28
JMD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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